

09/621,830

binder adhesive may contain a hot melt or the hot melt may be applied to the free surface of the binder adhesive. The hot melt adhesive is bonded to a surface, such as a rubber pad, using heat and pressure. The release adhesive and paper sheet are then removed. In one process configuration, a flock-coated adhesive carrier sheet, a solid pre-formed binder adhesive film or heat seal film, and the rubber base material are thermally fused together in a drying oven.

Please amend the paragraph beginning at page 5, line 6, as follows:

A flocked transfer 1 of the present invention is shown in FIG. 2. The transfer 1 of the present invention includes a release sheet 3 to which a conventional release agent 5, such as wax, has been applied. The release agent is applied to the sheet in the shape of the pattern of the flocking. Flocking 7 is then applied to the release agent, and hence to the release sheet, to form the transfer. The flocking 7 is applied, for example, in the manner as described in my prior patent, U.S. Pat. No. 4,810,549, which is incorporated herein by reference. Unlike the prior art processes, the transfer 1 of this embodiment is made without the use of a binder adhesive or a hot melt adhesive. As is discussed below, a thermosetting film is used to adhere the transfer to a substrate.

SR  
12/5/07

Please amend the paragraph beginning at page 5, line <sup>15</sup>~~8~~, as follows:

An article of manufacture, such as an item of clothing having a transfer 1 applied thereto, a mouse pad, coaster, or other item having a flocked surface is easily produced using the transfer 1. The article of manufacture 11 is produced by positioning a hot melt or thermosetting permanent adhesive sheet 13 between a substrate 15 and the flocked release sheet. The ~~hot-melt~~ sheet is, for example, a sheet of thermosetting polyester, available from Bostik, Inc. The ~~hot-melt~~ sheet can also be made from a thermosetting polyurethane. Any other thermosetting film should also work well. The substrate can be an item of clothing, a rubber pad (for producing a mouse pad or coaster), etc. The ~~hot-melt~~ sheet can be precut to correspond to the shape of the transfer 1. The transfer 1 is then positioned on the ~~hot-melt~~ sheet with the flock 5 against the ~~hot-melt~~ sheet 13. Heat is applied to the transfer through the release sheet to activate the ~~hot-melt~~ permanent adhesive sheet. The ~~hot-melt~~ sheet then acts to both bind the flock 5 together and to adhere the flock 5 to the substrate 15.

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Reply to Office Action of November 15, 2006

**Amendments to the Specification:**

1245/07 SR  
Please replace the paragraph beginning at page <sup>6</sup>~~7~~, line <sup>10</sup>~~24~~, as follows:

--Articles, such as mouse pads or coasters, in which the entire top surface of the article is covered with the flocking can be produced on a continuous basis, as shown in FIGS. 3 and 5. Rolls 21, 23, and 25 of a flocked release sheet 1, the thermoplastic hot melt film 13, and the substrate 15, are provided. The three parts are brought together at a lamination station 33. Rollers can be provided in front of the station 33 so that the three elements are adjacent each other as they enter the lamination station. Rollers can be provided in front of the station 33 so that the three elements are adjacent as they enter the lamination station. In the lamination station, heat and pressure are applied to the three sheets (the flocked release sheet, the hot melt film, and the substrate) to melt the hot melt film. The melted hot melt film will then cure or cross-link, as noted above, to adhere the flock to the substrate. A web 35 exits the laminating station. The web 35 is then allowed to cool. The web 35 is ultimately directed to a cutting station where it is cut into individual articles. Once the web 35 is cooled, it can be directed immediately to a cutting station (after the sheet 35 cools), or can it can be wound up on an uptake roller to be cut into individual articles at a later time, or at a different location. At the cutting station, the release sheet 3 is removed from the flock and gathered on a take-up roll or is otherwise disposed of. After the release sheet has been removed from the flock, the substrate with the flock adhered thereto is cut to form the articles 11. It is also likely that one could remove the release liner either before or after the die cutting procedure. As shown in FIG. 3, a fringe material 50 can be applied to one pair but not the other pair of opposed peripheral edges of the flocked release sheet 1 ~~or substrate 15~~ during this manufacturing process.--

09/621,830

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SR  
12/5/07

Please amend the paragraph beginning at page 5, line <sup>15</sup> 8, as follows:

--An article of manufacture, such as an item of clothing having a transfer 1 applied thereto, a mouse pad, coaster, or other item having a flocked surface is easily produced using the transfer 1. The article of manufacture 11 is produced by positioning a ~~hot-melt or~~ thermosetting permanent adhesive sheet 13 between a substrate 15 and the flocked release sheet. The sheet is, for example, a sheet of thermosetting polyester, available from Bostik, Inc. The sheet can also be made from a thermosetting polyurethane. Any other thermosetting film should also work well. The substrate can be an item of clothing, a rubber pad (for producing a mouse pad or coaster), etc. The sheet can be precut to correspond to the shape of the transfer 1. The transfer 1 is then positioned on the sheet with the flock 5 against the sheet 13. Heat is applied to the transfer through the release sheet to activate the permanent adhesive sheet. The sheet then acts to both bind the flock 5 together and to adhere the flock 5 to the substrate 15. Preferably, to assemble the article, the flocked release sheet, the permanent adhesive sheet (which is preferably the thermosetting film), and the substrate are brought together and passed through a heat-laminating press where the three parts are subject to temperature of about 300°F (about 150°C) and pressure (about 40-50 psi) for about 30 seconds. It has been found that a medium-to-firm pressure has been most advantageous in providing for assembly of this type of plush flocked transfer. The pressure and heat will cause the permanent adhesive sheet to adhere to the flock and the substrate. Additionally, the thermosetting film will cross-link or cure, to give a strong attachment of the flock to the substrate.--